

Work Order ID 55171-1

split



Page 1

January 08, 2010 11:26:45 AM

Item ID: D3781-041

Accept



Setup Start



Revision ID:

Item Name: Lateral Cushion Assembly

Stop



Start Date: 1/8/2010 Start Qty: 6.00

Required Date: 1/25/2010 Req'd Qty: 6.00

136



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: *mf*

Date: *10-01-08*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr	Revision Nbr
D3781	Rev D

100

0.00



Purchasing

Purchasing

Memo

Issue P/O: *11070*

Ship with D3781-1 SUPPORTING PLATE

Material: SKANDIA HR150 POLYFOAM (4.6 LBS/CU FT) AND COVER
D3781-1/-3 ASSEMBLY WITH SURREY SILVER SUNSET UPHOLSTERY
FABRIC P/N SY-11. BOND FABRIC USING 3M 1300/1300L ADHESIVE
(0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S
INSTRUCTIONS

THREAD:MIL-VT-295 TYPE2 CLASS A,GREY NYLON THREAD,4-6
STITCHES PER INCH,USE 1/2" MIN BACKSTITCH,NO LOOSE THREADS.

Possible Supplier: AEROTEX INTERIORS INC.

Material release note is required

CL 10/01/08

(6)

110

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Packaging

Memo

0.00

CL 1/4/22 (3)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55171

January 08, 2010 11:26:45 AM



Page 2

Item ID: D3781-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Lateral Cushion Assembly

Start Date: 1/8/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 1/25/2010 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00

⇒ 5.0/6.1/5



QC

Memo

0.00

Quality Control

(x3)

130

Identify as per dwg & Stock Location: 185

0.00



Packaging

Memo

0.00

Packaging

10-1-25

(3x) S

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/26

MF 10-1-26

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

January 08, 2010 11:26:45 AM

Page 1

Work Order ID: 55171



Parent Item: D3781-041



Parent Item Name: Lateral Cushion Assembly

Start Date: 1/8/2010

Required Date: 1/25/2010

Comments: IPP Rev:A 08-05-05 new issue DD verified by:EC
IPP Rev:B 08-07-22 revB as per dwg DD verified by:EC
IPP Rev:C 09-01-08 rev.C as per dwg DD verified by:ec

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ D3781-1	Replacement	Mfg/ Manufactured	Bin No	Primary	Last	Route	Unit of Each	Qty on 6.0000	Remaining 6.0000	Qty	Date	Status
Supporting Plate												



1/14/10 (6)

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

51716

6

6

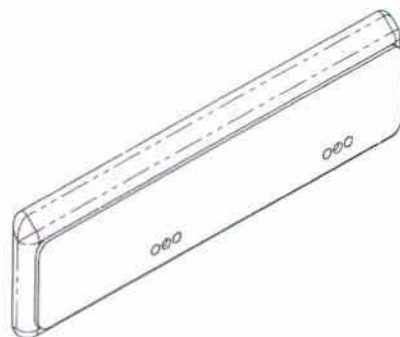
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

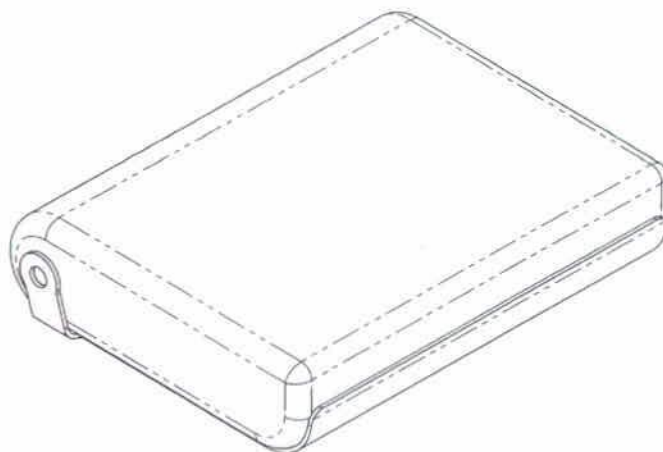
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3781-041 LATERAL CUSHION ASSY
(UPHOLSTERY FABRIC NOT SHOWN FOR CLARITY)



D3781-043 ARMREST CUSHION
(UPHOLSTERY FABRIC NOT SHOWN FOR CLARITY)

#55171

RELEASED
06/11/11

D	REDESIGNED BASED ON FEEDBACK FROM END USERS AT HAJ 2009	MB	09.05.21
C	REDESIGNED FOR COMPATIBILITY WITH BHT 204 SEATS	MB	08.11.10
B	REDESIGNED: ADDED DETAIL A (ZN 87-1)	MB	08.07.15
A	NEW ISSUE	MB	08.04.29
REV		BY	DATE

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. I
MFG. APPR.		D3781	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		CUSHION ASSEMBLY	NTS
DATE	09.05.21	COPYRIGHT © 2009 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

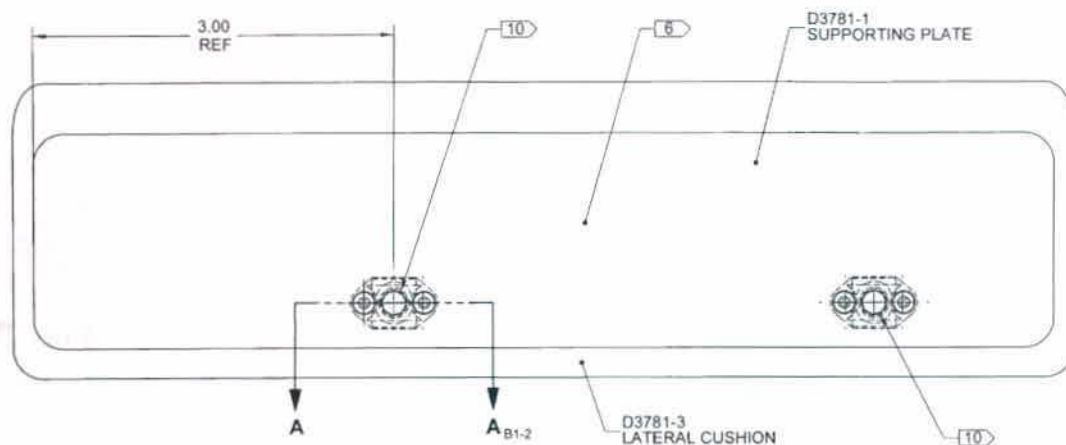
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

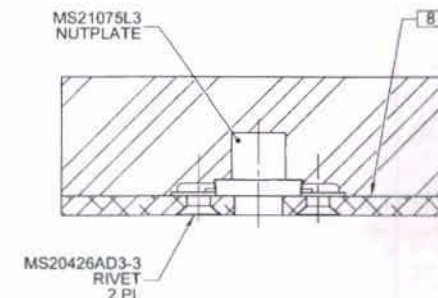
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3781-041	CUSHION ASSEMBLY
11	1	D3781-1	SUPPORTING PLATE
12	1	D3781-3	LATERAL CUSHION
22	2	MS21075L3	NUT PLATE (OR MS21075-3)
23	A/R	SY-111	SURREY SILVER SUNSET UPHOLSTERY FABRIC
24	A/R	1300	3M SCOTCH-GRIP ADHESIVE
25	4	MS20426AD3-3	RIVET



D3781-041 LATERAL CUSHION ASSEMBLY
(UPHOLSTERY FABRIC NOT SHOWN FOR CLARITY)



SECTION A-A
2 PL, SCALE 2X

D3781-041 NOTES:

- 1) MATERIAL: COVER D3781-1/-3 ASSEMBLY WITH SURREY SILVER SUNSET UPHOLSTERY FABRIC P/N SY-111.
BOND FABRIC USING 3M 1300/1300L ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
THREAD: MIL-VT-295 TYPE II CLASS A, GREY NYLON THREAD, 4-6 STITCHES PER INCH, USE 1/2" MIN BACKSTITCH, NO LOOSE THREADS
POSSIBLE SUPPLIER: AEROTEX INTERIORS INC.
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3781-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.18 lbs
- 8) BOND D3781-3 CUSHION TO D3781-1 SUPPORTING PLATE USING 3M 1300 ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 9) IT IS ACCEPTABLE TO RELIEVE D3781-3 CUSHION WHERE THE NUTPLATES ARE LOCATED TO ENSURE PROPER CONTACT WITH D3781-1 SUPPORTING PLATE
- 10) HOLES MUST BE FREE OF ADHESIVE AND FABRIC

RELEASED
29/07/2010

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3781	REV. D
MFG. APPR.		TITLE CUSHION ASSEMBLY	SHEET 2 OF 6
APPROVED			SCALE
DE APPR.			NTS
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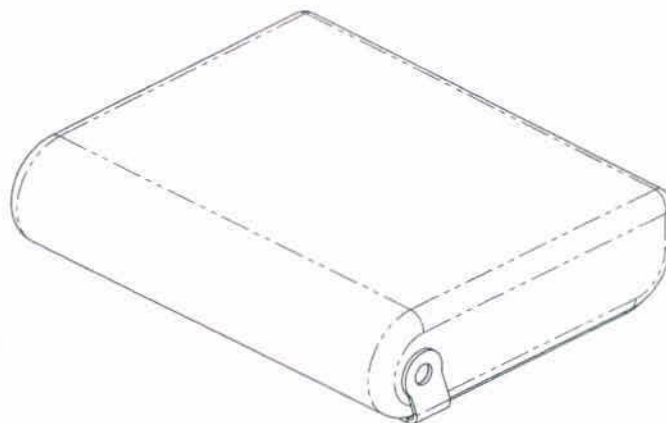
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

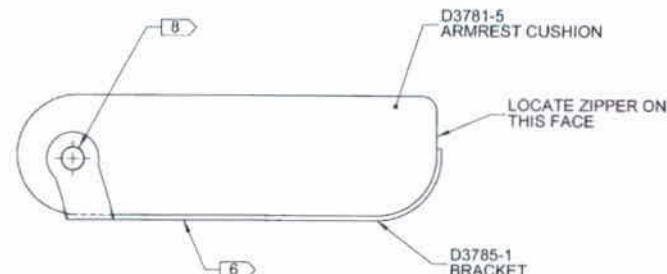
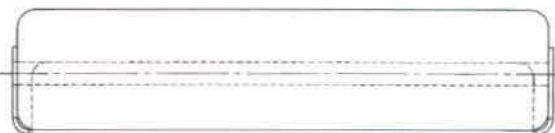
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

•NOTE: Date & initial all entries



D3781-043 LATERAL ARMREST CUSHION BASE ASSY
(UPHOLSTERY FABRIC NOT SHOWN FOR CLARITY)



ITEM	QTY -043	P/N	DESCRIPTION
1	X	D3781-043	ARMREST CUSHION ASSEMBLY
11	1	D3785-1	BRACKET
12	1	D3781-5	ARMREST CUSHION
21	A/R	SY-111	SURREY SILVER SUNSET UPHOLSTERY FABRIC
22	A/R	1300	3M SCOTCH-GRIP ADHESIVE

D3781-043 NOTES:

- 1) MATERIAL: COVER D3781-5/D3785-1 ASSEMBLY WITH SURREY SILVER SUNSET UPHOLSTERY FABRIC P/N SY-111.
THREAD: MIL-VT-295 TYPE II CLASS A, GREY NYLON THREAD, 4-6 STITCHES PER INCH, USE 1/2" MIN BACKSTITCH, NO LOOSE THREADS
ZIPPER P/N: AI-Z021
POSSIBLE SUPPLIER: AEROTEX INTERIORS INC.
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3781-043" USING FINE POINT PERMANENT INK MARKER AFTER RECEIVING
- 7) WEIGHT: 1.14 lbs
- 8) DO NOT COVER HOLES WITH FABRIC

RELEASED
09/07/14 AM

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3781	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		CUSHION ASSEMBLY	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

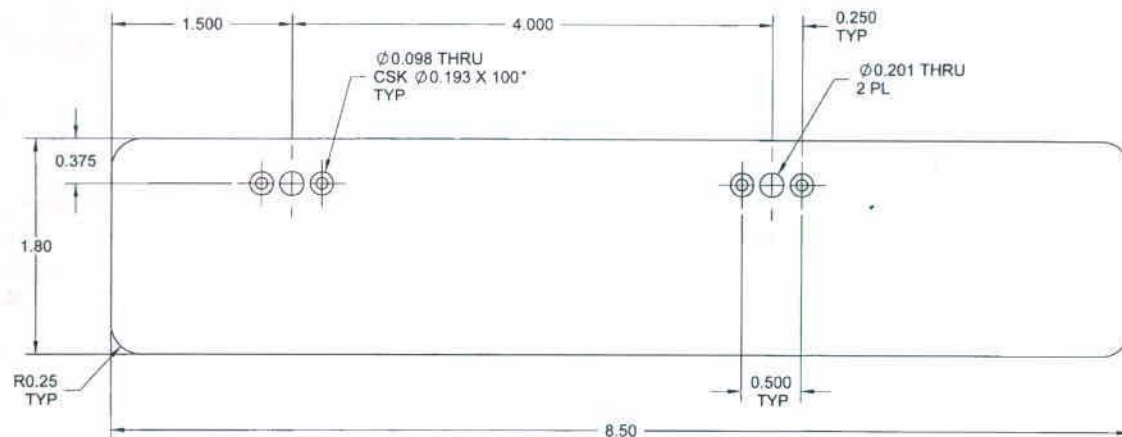
• **NOTE:** Date & initial all entries

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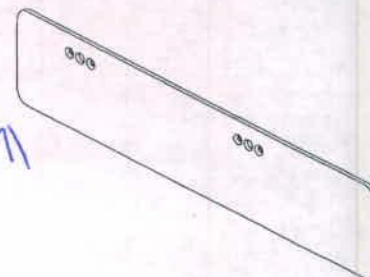
C

B



D3781-1 SUPPORTING PLATE

#55171



RELEASED
09/07/14

D3781-1 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF. DART SPEC. M6061T6S.080
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.12 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>ALS</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>MS</i>	D3781	SHEET 4 OF 6
APPROVED	<i>W</i>	TITLE	SCALE
DE APPR.	<i>#</i>	CUSHION ASSEMBLY	NTS
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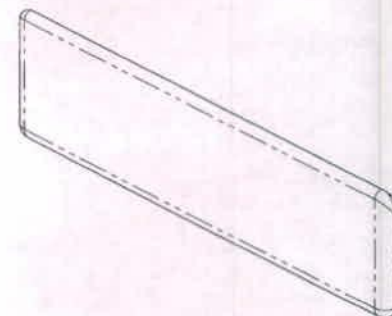
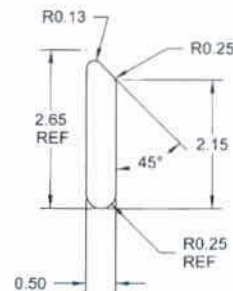
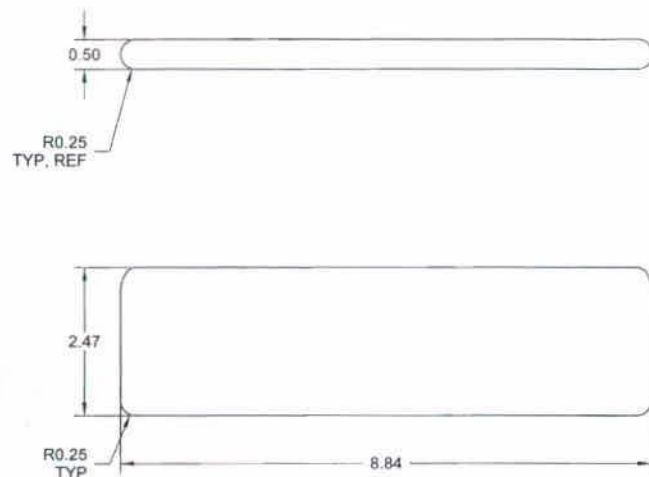
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

* NOTE: Date & initial all entries



#55171

D3781-3 LATERAL CUSHION

D3781-3 NOTES:

- 1) MATERIAL: SKANDIA HR150 POLYFOAM (4.6 LBS/CU FT)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.06 lbs
- 8) POSSIBLE SUPPLIER: AEROTEX INTERIORS INC.

RELEASED
2/12/21

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3781	SHEET 5 OF 6
APPROVED		TITLE	SCALE
DE APPR.		CUSHION ASSEMBLY	NTS
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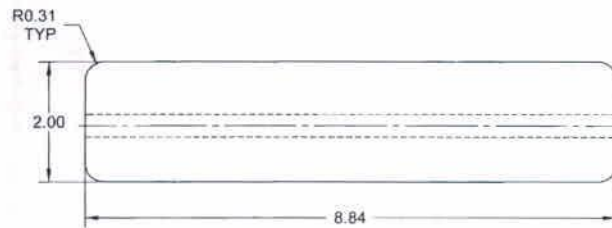
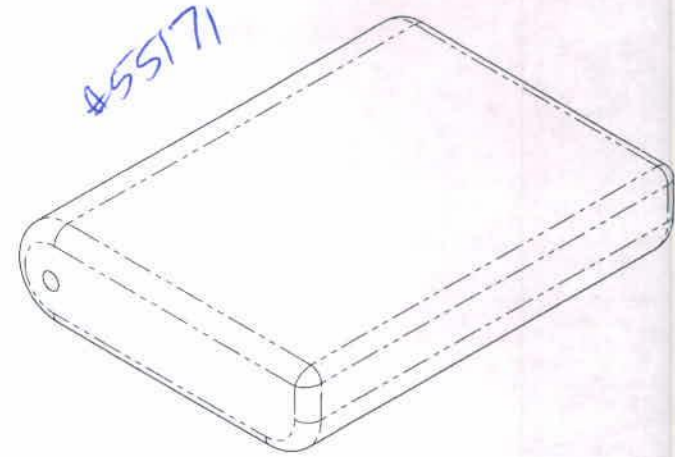
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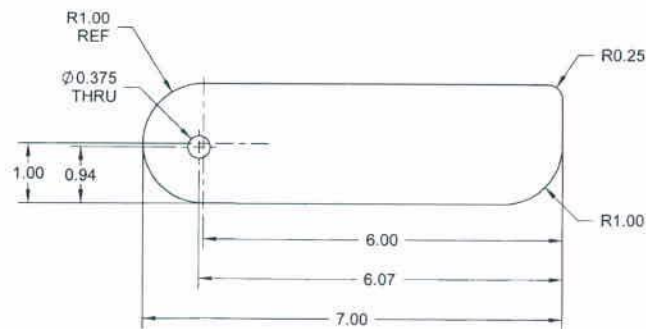
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

* NOTE: Date & initial all entries



D3781-5 ARMREST CUSHION



RELEASED

D3781-5 NOTES:

- 1) MATERIAL: SKANDIA HR150 POLYFOAM (4.6 LBS/CU FT)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.67 lbs
- 8) POSSIBLE SUPPLIER: AEROTEX INTERIORS INC.

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. D
MFG. APPR.		D3781	SHEET 6 OF 6
APPROVED		TITLE	SCALE
DE APPR.		CUSHION ASSEMBLY	NTS
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

* NOTE: Date & initial all entries



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO11070

Purchase Order Date 1/08/10

PO Print Date 1/08/10

Page Number 1 of 1

Order From :

VC-AER003

AEROTEX INTERIORS INC.
#24-2333 18TH AVENUE N. E.
CALGARY, AB T2E 8T6
CA

FAXED
01/08/10

Contact Name
Vendor Phone 403 295 8770
Vendor Fax 403 313 0793
Vendor Account Nbr

Buyer Chantal Lavoie
Requisition Nbr
Tax Resale Nbr 10127-2607
Terms Net 30
Currency CAD
FOB

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	d3781-041P	Lateral cushion ass'y	1/22/10 Yes	6.00 Each	FedEx PI ppd	\$175.0000	\$1,050.00

CERTIFICATE OF CONFORMITY
REQ'D UPON DELIVERY

Special Inst: MATERIAL: SKANDIA HR150
POLYFOAM (4.6 LBS/CU FT) AND
COVER
D3781-1/-3 ASSEMBLY WITH SURREY
SILVER SUNSET UPHOLSTERY
FABRIC P/N: SY-11. BOND FABRIC
USING 3M 1300/1300L ADHESIVE
(0.002" TO 0.010" THICK)

MATERIAL CERTIFICATION
REQ'D UPON DELIVERY

THREAD: MIL-VT-295 TYPE 2 CLASS A.
GREY NYLON THREAD, 4-6
STITCHES PER INCH, USE 1/2" MIN.
BACKSTITCH, NO LOOSE THREADS
B55171

2	D3781-043P	armrest cushion ass'y	1/22/10 Yes	2.00 Each	FedEx PI ppd	\$175.0000	\$350.00
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Special Inst: MATERIAL & THREADING SAME AS
ABOVE
B55173

PO Total: \$1,400.00

Change Nbr: 1

Change Date: 1/08/10

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable



#24, 2333 - 18 Ave NE
Calgary, AB T2E 8T6
Phone: (403) 295-8770
Fax: (403) 313 0793

Packing Slip

Date	Packing Slip#
1/21/2010	6141

Ship To	
Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7 Canada	
Customer Phone	Customer Fax
613.632.5200	613.632.1053
Ship Via	Courier Acct No.
FedEx	15179324-0

Invoice To
Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7 Canada

Ship Date	P.O. No.
1/21/2010	PO11070

Description	ALT. Part Number	Part Number	Qty
LATERAL CUSHION ASSY.		D3781-041P	3
ARMREST CUSHION ASSY.		D3781-043P	2
GST On Sales			

Thank you for doing business with Aerotex Interiors!

www.aerotexinteriors.com

GST/HST No. 139110308



- Unit 24, 2333 - 18 Ave NE, Calgary AB T2E 8T6 - Phone: (403) 295 -8770 - Fax: (403) 313 - 0793 -

CERTIFICATION OF CONFORMANCE

Customer Purchase Order:
Our Work Order:

PO11070
6141

THIS IS TO CERTIFY THAT THE FOLLOWING MATERIALS HAVE BEEN USED IN THE WORK ORDER STATED ABOVE:

MATERIAL - SURREY SILVER SUNSET
THREAD - V-T- TYPE II GREY
FOAM - HR150

8/10/10/10/5

HAS BEEN FABRICATED TO ESTABLISHED SPECIFICATION TO CONFIRM WITH
FAR 27.853(a), 29.853(a) DWG. 3781-041, 3781-043

SOLD TO:

DART AEROSPACE LTD., 1270 ABERDEEN STREET, HAWKESBURY, ON K6A 1K7

AUTHORIZED REPRESENTATIVE

A handwritten signature in black ink, appearing to be 'S. J. ...', is written over a horizontal line.